

Work Order ID 78373-1

January-06-12 12:44:45 PM

\*78373\*

~~PRELIMINARY~~  
~~ISSUE~~

Page 1

Item ID: D4571-041  
Revision ID:  
Item Name: Tail Rotor Pedal Disabling

Accept

\*N9000040100\*

Setup Start \*NS1\*  
Stop \*NS2\*

Start Date: 06/01/2012 Start Qty: 5.00 \*5\*  
Required Date: 20/01/2012 Req'd Qty: 5.00 \*5\*

Cust Item ID:  
Customer:

Reference:

Approvals: Process Plan: M.C.J.  
QC:

Date: 12/01/10 Tooling:  
Date: SPC (Y/N):

Date: Run Start \*NR1\*  
Date: Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.  
Code Qty Qty Number Stamp

Draw Nbr

Revision Nbr

D4571

PA1

Pick Kit

0.00

\*100\*

Packaging

Memo

0.00

Packaging

110

0.00

\*110\*

Small Fab

Memo

0.00

Small Fab

ASSEMBLE AS PER DWG

120

QC'S- Inspect part completeness to step on W/O

0.00

\*120\*

QC

Memo

0.00

Quality Control

8/26/12

to PA1 Pmg.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 78373

January-06-12 12:44:45 PM

**\*78373\***

Page 2

Item ID: D4571-041

Revision ID:

Item Name: Tail Rotor Pedal Disabling

Start Date: 06/01/2012 Start Qty: 5.00

Required Date: 20/01/2012 Req'd Qty: 5.00

Reference:

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Stop **\*NS2\***

Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

Identify as per dwg & Stock Location:

0.00

**\*130\***

Packaging

Memo

PPP-78703. SP 12-01-12.

0.00

Packaging

140

QC21-Final Inspection - Work Order Release

0.00

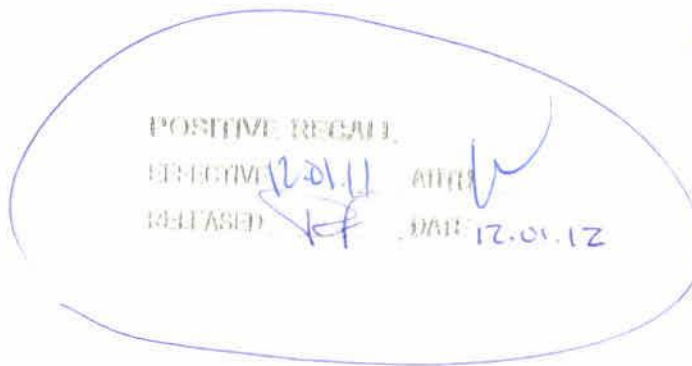
**\*140\***

QC

Memo

0.00

Quality Control



12/1/12 [Signature]  
[Signature]  
12-01-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



January-06-12 12:44:49 PM

Page 1

**Parent Item Name:** Tail Rotor Pedal Disabling

\*D4571-041\*

Required Qty: 5.00

Comments: IPP REV:A 12.01.06 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
97395A461 *97395A461*		Purchased	No			100	Each	0.0000	2	10	8	12/01/12	
Dowel Pin									**				
D3373-5 *D3373-5*		Manufactured	No			100	Each	51.0000	1	5	8	12/01/12	
Cam Lock									**				
				<u>Location</u>									
				ST040									
					22383								
D3385-3 *D3385-3*		Manufactured	No			100	Each	96.0000	1	5	8	12/01/12	
Hinge									**				
				<u>Location</u>									
				ST041									
					22387								
D4571-1 *D4571-1*		Manufactured	No			100	Each	0.0000	1	5	8	12/01/12	
Base									**				
D4571-3 *D4571-3*		Manufactured	No			100	Each	0.0000	1	5	8	12/01/12	
Cover									**				
MS51957-41 *MS51957-41*		Purchased	No			100	Each	0.0000	4	20	8	12/01/12	
Screw									**				

Screw

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

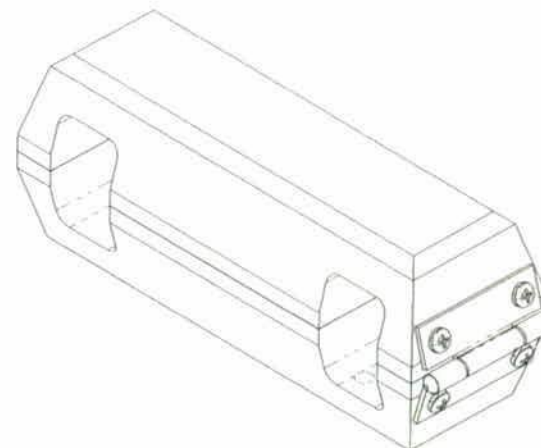
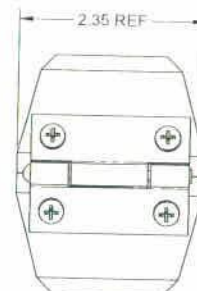
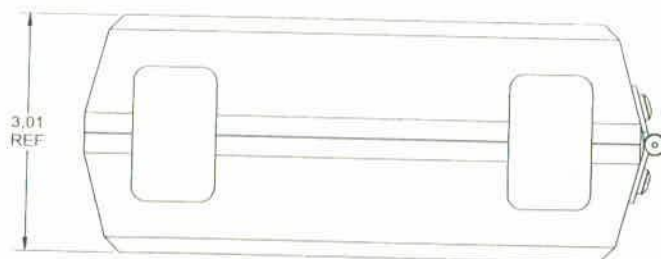
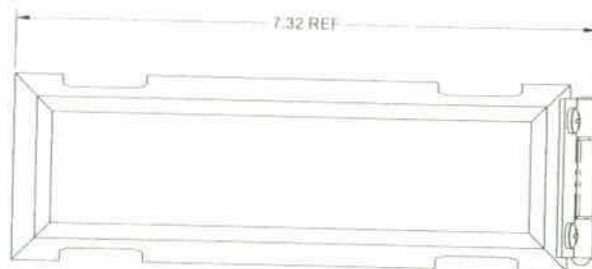
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

ITEM	QTY -041	QTY -051	P/N	DESCRIPTION
	X		D4571-041	TAIL ROTOR DISABLING KIT
	1	X	D4571-051	PEDAL LOCK
1	2		97395A4561	DOWEL PIN (MCMaster CARR)
2	1		D3373-5	CAM LOCK ASSEMBLY
3	1		D3385-3	HINGE
4	1		D4571-1	BASE
5	1		D4571-3	COVER
6	4		MS51957-41	PH-HD SCREW, #8



**D4571-051 PEDAL LOCK**

78373 MLC  
12/01/06

**PRELIMINARY A1**  
11.12.22 (RP)

PA1	PRELIMINARY	RP	11.12.21
REV.	DESCRIPTION	BY	DATE
DESIGN	RP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RP		
CHECKED	MP	DRAWING NO.	REV. PA1
MFG. APPR.		D4571	SHEET 1 OF 4
APPROVED	MP	TITLE	SCALE
DE APPR.		PEDAL LOCK	NTS
DATE	11.12.22	COPYRIGHT © 2011 BY DART AEROSPACE LTD <small>THIS DRAWING IS THE PROPERTY OF DART AEROSPACE LTD. IT IS TO BE USED FOR THE PURPOSES SPECIFIED ONLY. IT IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE LTD.</small>	

Dart Aerospace Ltd

W/O: 78373-

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
12-1-12		<del>D3384-047</del> ADD D3384-047 B 77187 x 1 to Kit per MiK Patshe HX 81 x 1 B 114383	YH	12-01-12	1		S reluliz
		NAS1149F0463P x 2 <u>M116702</u>					

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

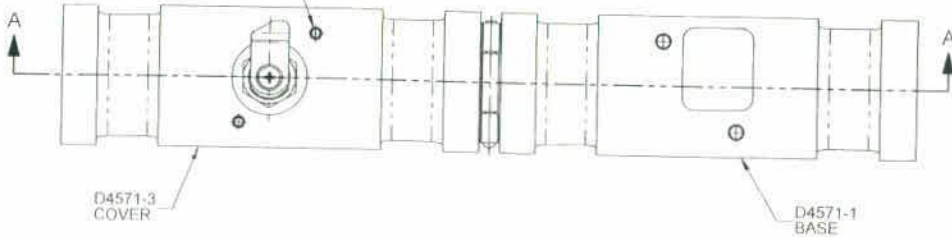
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



78373

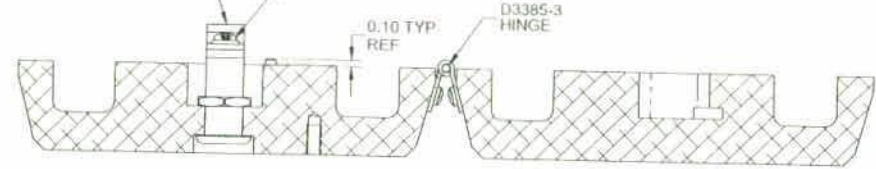
97395A4561  
DOWEL PIN (MCMASTER CARR)



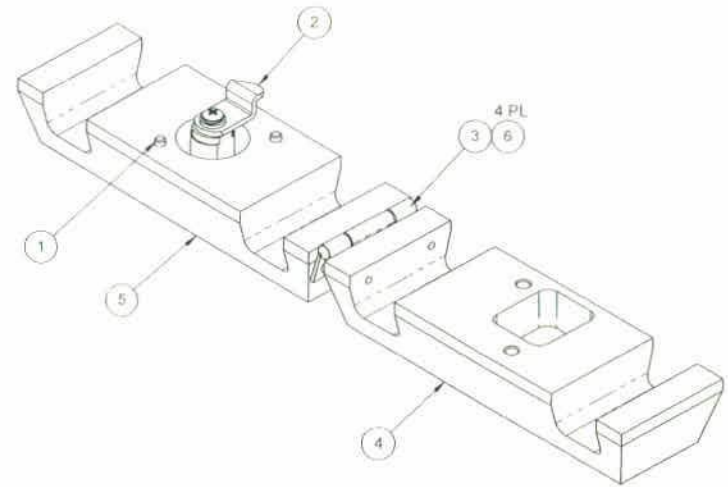
**D4571-051 PEDAL LOCK ASSEMBLY**

D3373-5  
CAM LOCK ASSEMBLY  
PEDAL LOCK

#10 LOCK WASHER REF  
#10-32 PN-HD SCREW REF  
(AS PER D3373-5)



**SECTION A-A**



**PRELIMINARY A1**  
11.12.22 (RP)

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.75 lbs

DESIGN	RP	<b>DART AEROSPACE LTD</b>	
DRAWN	RP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MP	DRAWING NO	REV. PA1
MFG. APPR.		D4571	SHEET 2 OF 4
APPROVED	<i>MP</i>	TITLE	SCALE
DE APPR.		PEDAL LOCK	NTS
DATE	11.12.22	<small>COPYRIGHT © 2011 BY DART AEROSPACE LTD          THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE LTD. IT IS TO BE USED FOR THE PURPOSES SPECIFIED IN THE ORDER. NO PART OF THIS DOCUMENT IS TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

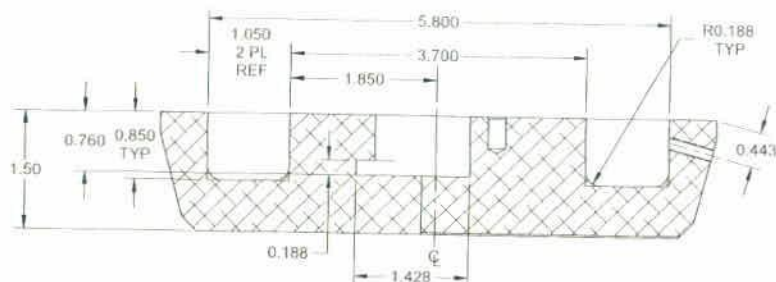
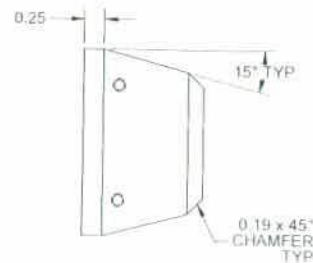
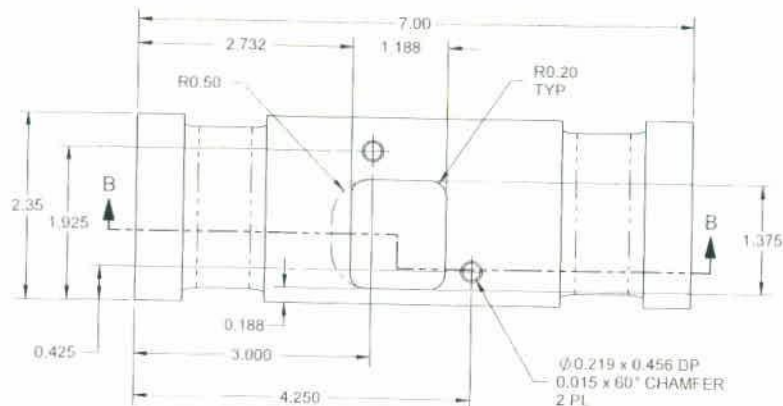
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

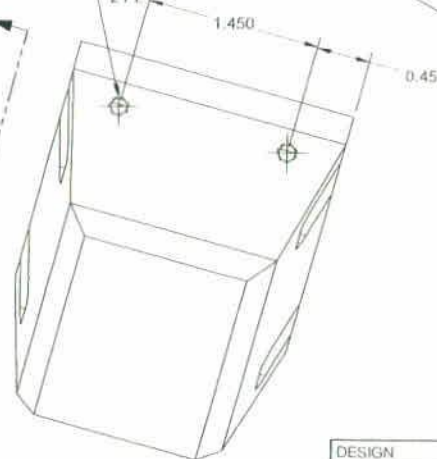
**NOTE:** Date & initial all entries

70373

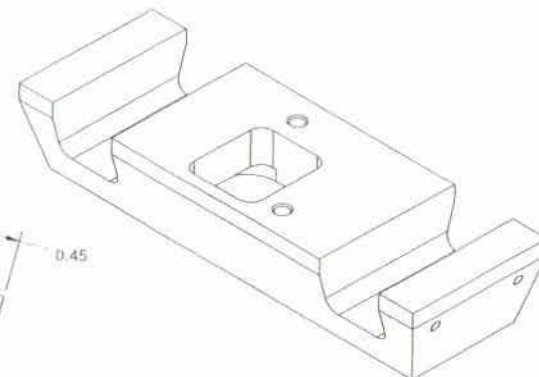


SECTION B-B

DRILL  
 $\phi 0.136$  THRU  
TAP 8-32 UNC  
2 PL



VIEW D-D



NOTES:

- 1) MATERIAL 6061-T6/T651 PER QQ-A-200/8 OR QQ-A-225/8 OR ASTM B211 OR ASTM B221 REF. DART SPEC. M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) MASK INSIDE HOLES PRIOR TO FINISH

D4571-1 BASE

PRELIMINARY A1  
11.12.22 (RP)

DESIGN	RP	DART AEROSPACE LTD	
DRAWN	RP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MP	DRAWING NO.	REV. PA1
MFG. APPR.		D4571	SHEET 3 OF 4
APPROVED	AP	TITLE	SCALE
DE APPR		PEDAL LOCK	NTS
DATE	11.12.22	COPYRIGHT © 2011 BY DART AEROSPACE LTD	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

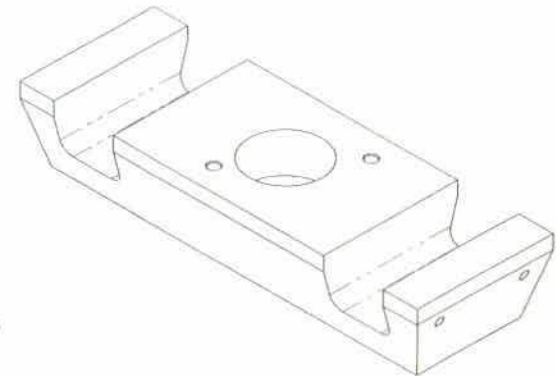
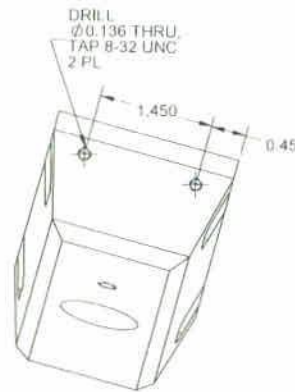
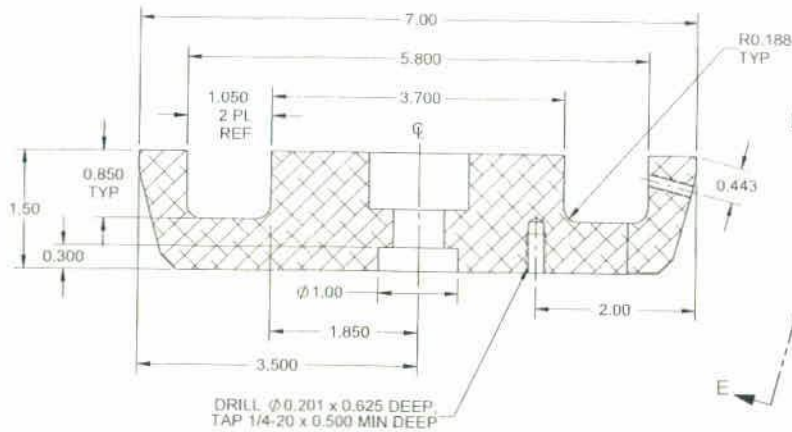
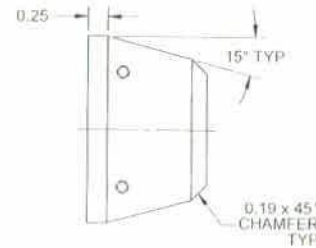
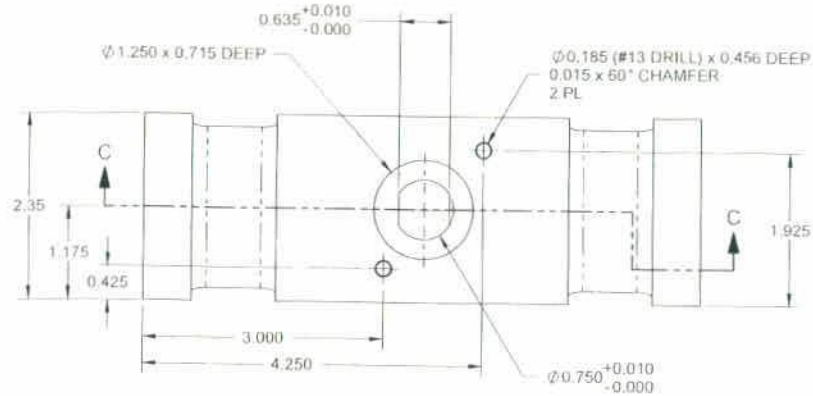
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



78373



# NOTES:

- 1) MATERIAL: 6061-T6/T651 PER QQ-A-200/B OR QQ-A-225/B OR ASTM B211 OR ASTM B221 REF: DART SPEC. M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) MASK INSIDE HOLES PRIOR TO FINISH

D4571-3 COVER

VIEW E-E

PRELIMINARY A1  
11.12.22 (RP)

DESIGN	RP	DART AEROSPACE LTD	
DRAWN	RP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MP	DRAWING NO.	REV. PA1
MFG APPR		D4571	SHEET 4 OF 4
APPROVED	MP	TITLE	SCALE
DE APPR		PEDAL LOCK	NTS
DATE	11.12.22	COPYRIGHT © 2011 BY DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

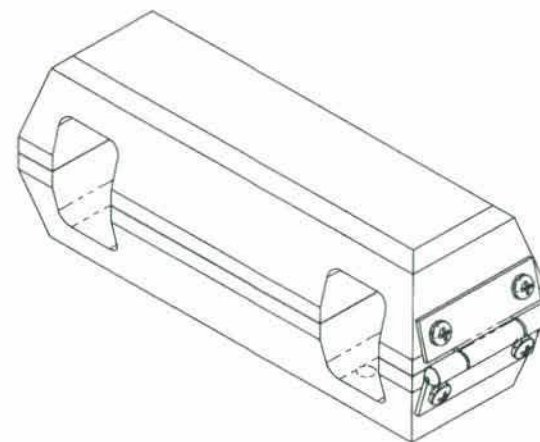
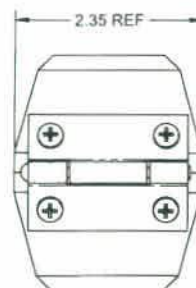
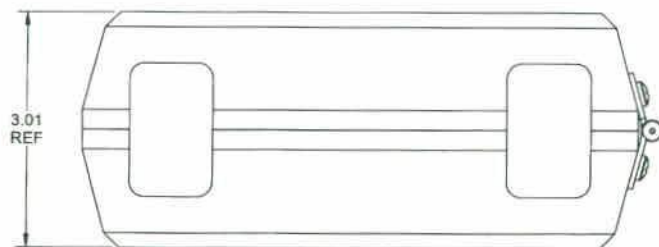
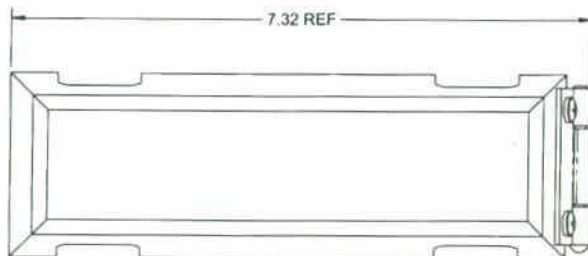
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	QTY -051	P/N	DESCRIPTION
	X		D4571-041	TAIL ROTOR DISABLING KIT
	1	X	D4571-051	PEDAL LOCK
1	1		D3373-5	CAM LOCK ASSEMBLY
2	1		D3385-3	HINGE
3	1		D4571-1	BASE
4	1		D4571-3	COVER
5	4		MS51957-41	PH-HD SCREW, #8
6	2		97395A461	DOWEL PIN (MCMaster CARR)



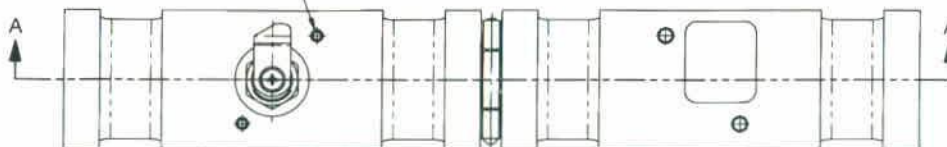
**D4571-051 PEDAL LOCK**

78373

RELEASED  
2012-01-10

A		NEW ISSUE	RP	12.01.06
REV	DESCRIPTION		BY	DATE
DESIGN	RP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
DRAWN	RP			
CHECKED	MP	DRAWING NO.	REV. A	
MFG APPR.		D4571	SHEET 1 OF 4	
APPROVED		TITLE	SCALE	
DE APPR.	N/A	PEDAL LOCK	NTS	
DATE	12.01.06		COPYRIGHT © 2012 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

97395A461  
DOWEL PIN (MCMASTER CARR)



D4571-3  
COVER

D4571-1  
BASE

# **D4571-051 PEDAL LOCK ASSEMBLY**

D3373-5  
CAM LOCK ASSEMBLY  
PEDAL LOCK

#10 LOCK WASHER REF  
#10-32 PN -HD SCREW REF  
(AS PER D3373-5)

0.10 TYP  
REF

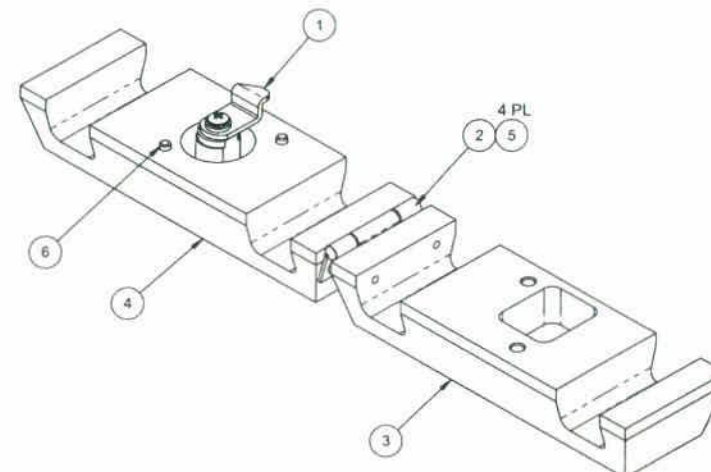
D3385-3  
HINGE



## **SECTION A-A**

### **NOTES:**

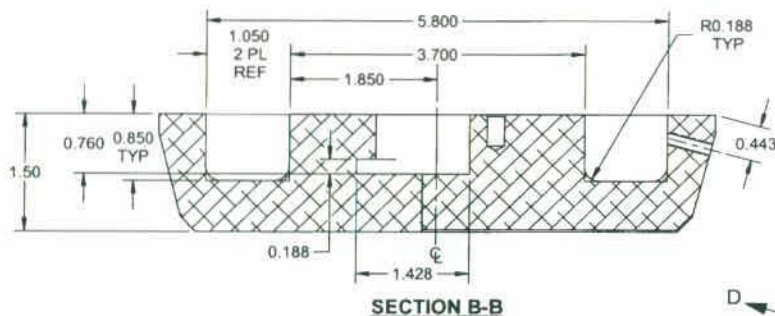
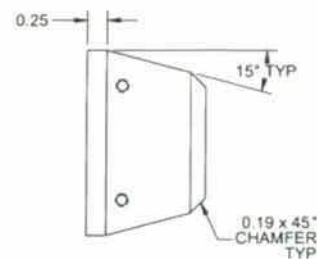
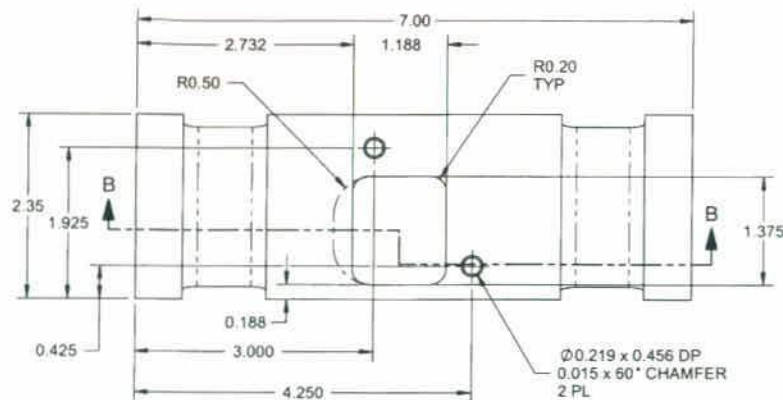
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.75 lbs



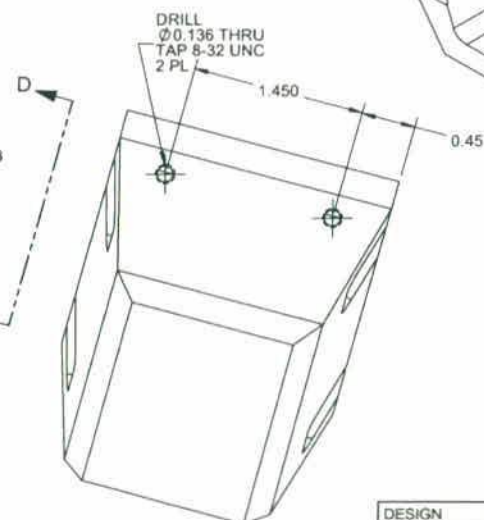
FILED  
2012-07-10

DESIGN	RP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RP		
CHECKED	MP	DRAWING NO.	REV. A
MFG. APPR.		D4571	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.	N/A	PEDAL LOCK	NTS
DATE	12.01.06	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRELIMINARY AND NOT FOR CONSTRUCTION. IT IS SUPPLIED ON THE UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

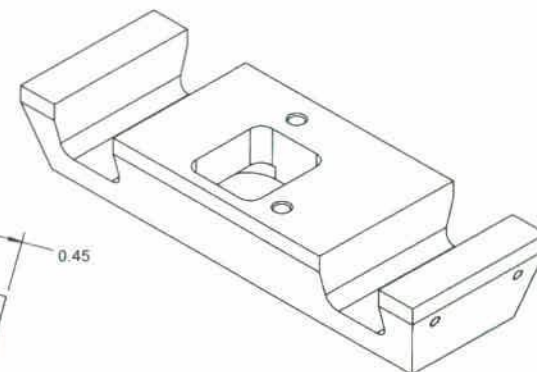




SECTION B-B



VIEW D-D



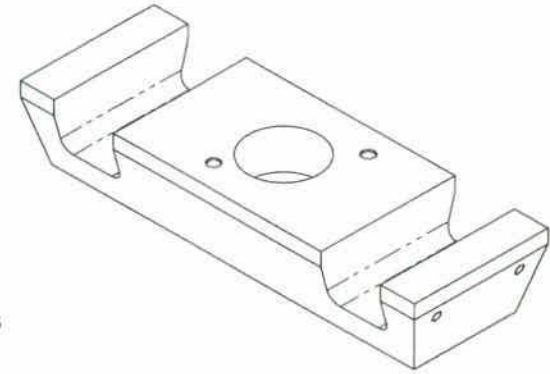
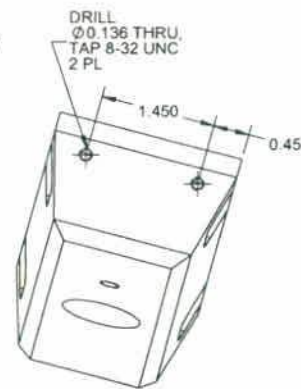
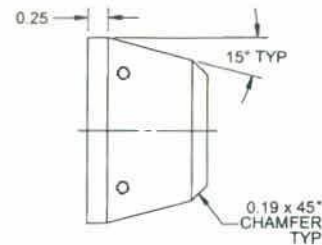
NOTES:

- 1) MATERIAL: 6061-T6/T651 PER QQ-A-200/8 OR QQ-A-225/8 OR ASTM B211 OR ASTM B221  
REF. DART SPEC. M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) MASK INSIDE HOLES PRIOR TO FINISH

D4571-1 BASE

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WP

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MFG. APPR.		D4571	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.	N/A	PEDAL LOCK	NTS
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